



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4435-041
Job Sheet 188185



Part No: D4435-041

Job Qty: 8 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 2/14/19

Created By: Marie Lajeunesse

Type: SOLD *sh*

Description:

Note: D4435 REV.C IPP REV:B 12.03.06 AS PER DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		1/14/19	0.02	0.56	Waterjet - Flow		<i>DC 19/03/08</i>
110	QC 2	8 pcs		1/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>DC 19/03/08</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

120 QC 8	8 pcs	1/14/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DAS
				QC 8 - 9	40
				QC 8 - 68	9-89 MAR 11 2019
				QC 8 - 67	
				QC 8 - 1 (A)	
130 Handfinish - 1-1 Chemical- B4B	8 pcs	1/14/19	0.00 0.28	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	D.P 19/03/12
135 QC 7	8 pcs	1/14/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BR 19-03-12
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
140 Powdercoat - 4 Black Sand - B4B	8 pcs	1/14/19	0.00 0.27	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 19-03-12
				Powdercoat - 4 - B4B	
150 QC 3	8 pcs	1/14/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	

				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
160 Small Fab - 2 - B4B	8 pcs	1/14/19	0.00 1.07	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
170 QC 5	8 pcs	1/14/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
190 Packaging 3-1 - Stock - B4B	8 pcs	1/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	

MAR 13 2019

DAS
40
9-89DAS
58
9-89

MAR 20 2019

DAS
40
9-89

ST09100

MAR 21 2019

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200	QC 21 - SA	8 pcs	1/14/19	0.00 0.00	QC 21 - SA - 21 QC 21 - SA - 70
Part Op 100 - 1-Cut D4435-1 as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - QC2 Waterjet-3 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8-4 (QC8- Inspect parts - second check) 130 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 135 - QC7-3 (QC7-Inspect Chemical Conversion Coat) 140 - Powdercoat4 (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 150 - QC3 (QC3- Inspect Part Finish) 160 - Small Fab-6 (Small Fab) 1- Cut rubber seal at 3.50" 2-Glue rubber seal to bracket as per dwg (SHEET 1, NOTE 8) 170 - QC5 (QC5- Inspect part completeness to step on W/O) 190 - Packaging3-2 (Identify as per dwg & Stock Location: _____) 200 - QC21 (QC21- Final Inspection - Work Order Release)					DAS 21 9-89 MAR 21 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.040	6061-T6 .040 Sheet	.3440 sf (.043 ea)	100-Waterjet - Flow - 1	S152150	
D4441-1	Rubber Seal	2.3328 ft (.2916 ea)	160-Small Fab - 2 - B4B	5092167	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	0	11	0
160-Small Fab - 2 - B4B	D4441-1	2	473	0
Part Specifications				
Specifications could not be found.				

Plex 1/21/19 2:42 PM Dart.Hadley.Shannon



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D4435-041
Job Sheet 188185



Part No: D4435-041

Job Qty: 8 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4435 REV.C IPP REV:B 12.03.06 AS PER DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		1/14/19	0.02	0.56	Waterjet - Flow		
110	QC	8 pcs		1/14/19	0.00	0.00	QC2 Waterjet-3		
120	QC	8 pcs		1/14/19	0.00	0.00	QC8-4		
130	HandFinish	8 pcs		1/14/19	0.00	0.28	HandFinish1		
135	QC	8 pcs		1/14/19	0.00	0.00	QC7-3		
140	Powdercoat	8 pcs		1/14/19	0.00	0.27	Powdercoat4		
150	QC	8 pcs		1/14/19	0.00	0.00	QC3		
160	Small Fab	8 pcs		1/14/19	0.00	1.07	Small Fab-6		
170	QC	8 pcs		1/14/19	0.00	0.00	QC5		
190	Packaging	8 pcs		1/14/19	0.00	0.00	Packaging3-2		
200	QC21-SA	8 Ea		1/14/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut D4435-1 as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
Descriptions: 140 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
160 - 1- Cut rubber seal at 3.50" 2-Glue rubber seal to bracket as per dwg (SHEET 1, NOTE 8)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.3440 sf (.043 ea)	100-Waterjet - Flow - 1	
D4441-1	Rubber Seal	2.3328 ft (.2916 ea)	160-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	0	11	0
160-Small Fab	D4441-1	2	483	0

Part Specifications

Specifications could not be found.

Plex 1/4/19 10:35 AM Dart.lajeunesse.marie

W3 Blue

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S160879



Part: D4435-041

Job No: 188185

Serial No/Batch: S160879

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/09/19